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C3-C-1

Job Sheet 200759



Part No: C3-C-1

Job Qty: 1 pcs

Part Name: Weldment C3 Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/17/19

Job Tracking No:

Due Date: 10/31/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 19302

Note: DWG C3-C Rev J IPP Rev A 18.03.28 New issue DP Verify DD/IPP Rev. B 19.04.25 drawing revision DP Verify DD/IPP Rev. C 19.05.03 drawing revision DP Verify DD/IPP Rev. D 19.07.23 drawing update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	10/31/19	10/31/19	0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MV Oct 25/19
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	10/31/19	10/31/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		EL
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		



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Container No: S226710



Part No: C3-C-1

Job No: 200759

Serial No/Batch: S226710

Revision: J

Plex 9/17/19 1:28 PM Dart.Renwick.Jennifer

						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	EL
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Powdercoat - 6 Fire Red - B4B	1 pcs	10/31/19	0.00	0.50		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BR 19-10-30
						Powdercoat - 4 - B4B	
140 QC 3	1 pcs	10/31/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	DAS
						QC 3 - 30	30
						QC 3 - 34	9-30
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150 Packaging 3-1 - Stock - B4B	1 pcs	10/31/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	DAS
						Packaging 3 - 9 - B4B	30
						Packaging 3 - 10 - B4B	9-30
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1	10/31/19	0.00 0.00	QC 21 - SA - 21	D&S
	pcs			QC 21 - SA - 70	21 OCT 30 2019
				QC 21 - SA - 53	9-30

Part Op 100 - 1-Fabricate C3-C-3, C3-C-4 and C3-C-5. 2-TACK WELD FOR INSPECTION BY: 12 USE WELDING JIG
 Descriptions: C3-19C. 2-Weld as per DWG. ***See notes 8,9,10 and 11***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Fire Red (Ref:4.3.5.10) per QSI005 4.3 START TIME: 11:00 OVEN TEMPERATURE: 820° FINISH TIME: 11:30 M225472

140 - QC3- Inspect Part Finish Ink stamp will be done on top level assembly.

150 - 1-Identify as per dwg & Stock Location: CAL60 2-Ink stamp will be done on top level assembly, identify with green tag.

160 - QC21- Final Inspection - Work Order Release

Job BOM

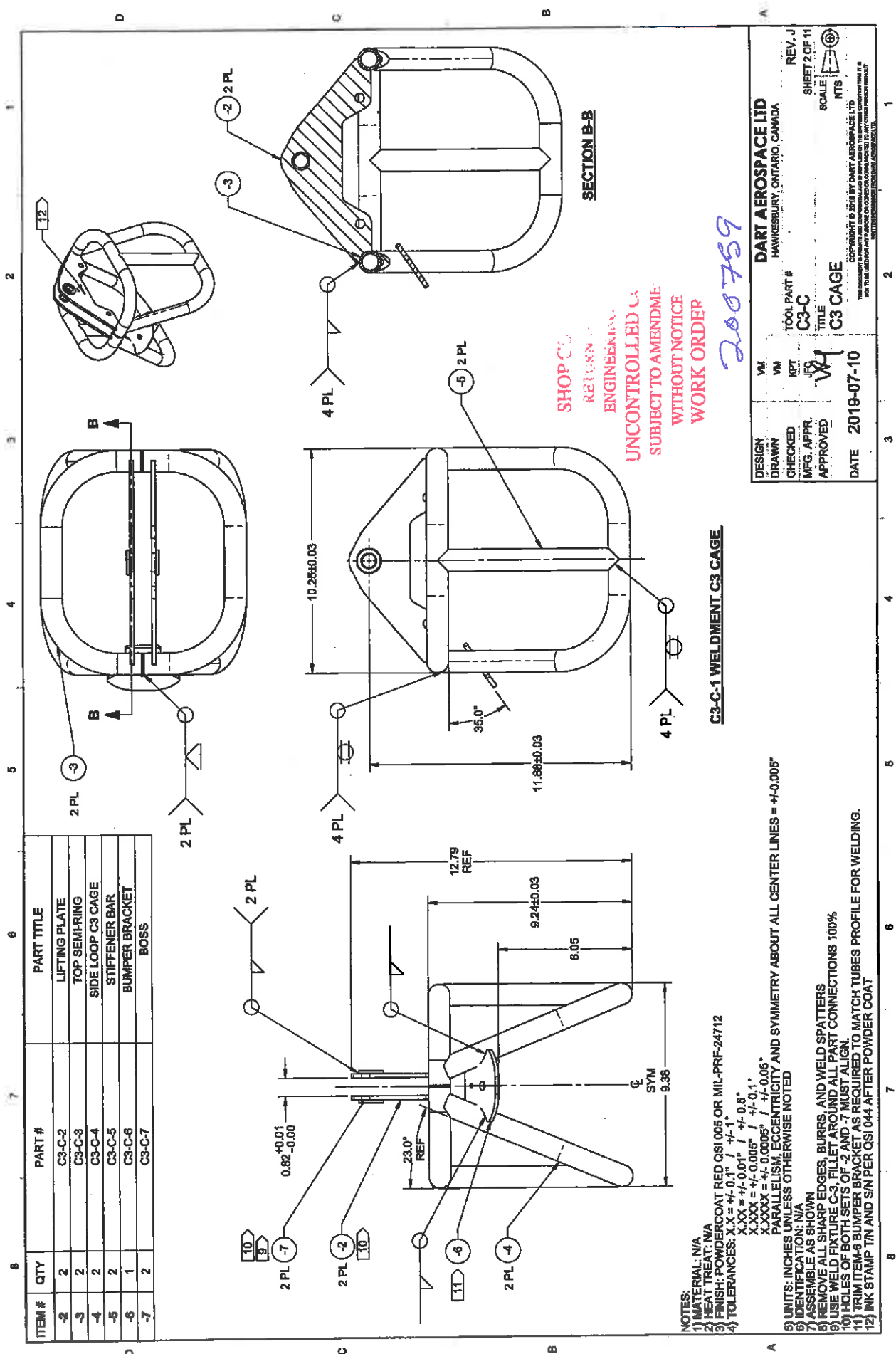
Part / Item	Component Name	Quantity	Operation	Container
C3-C-2	Lifting Plate	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<u>5217546</u>
C3-C-6	Bumper Bracket	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5219520</u>
C3-C-7	Boss	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<u>5181047</u>
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 0.120" Wall	8.7000 ft (8.7 ea)	100-Large Fab - Welded Assy-1	<u>5200823</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	C3-C-2	2	0	0
	C3-C-6	1	4	0
	C3-C-7	2	0	0
	MT-A513-T-1.000W0.120	9	163	0

Part Specifications

Specifications could not be found.



ITEM #	QTY	PART #	PART TITLE
-2	2	C3-C-2	LIFTING PLATE
-3	2	C3-C-3	TOP SEMI-RING
-4	2	C3-C-4	SIDE LOOP C3 CAGE
-5	2	C3-C-5	STIFFENER BAR
-6	1	C3-C-6	BUMPER BRACKET
-7	2	C3-C-7	BOSS

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: POWDERCOAT RED QSI 005 OR MIL-PRF-24712
4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 1^\circ$
XXX = $\pm 0.01"$ / $\pm 0.1^\circ$
XXXX = $\pm 0.005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

5) UNITS: INCHES UNLESS NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLY: N/A
8) REMOVE ALL SHARP EDGES, BURRS, AND WELD SPATTERS
9) USE WELD FIXTURE C-3; FILLET AROUND ALL PART CONNECTIONS 100%
10) HOLES OF BOTH SETS OF -2 AND -7 MUST ALIGN
11) TRIM ITEM-6 BUMPER BRACKET AS REQUIRED TO MATCH TUBES PROFILE FOR WELDING.
12) INK STAMP TIN AND SIN PER QSI 044 AFTER POWDER COAT

C3-C-1 WELDMENT C3 CAGE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

200759

DESIGN	VM	VM	DATE	2019-07-10
DRAWN	VM	VM		
CHECKED	VM	VM		
MFG. APPR.	VM	VM		
APPROVED	VM	VM		
TOOL PART #		C3-C		
TITLE		C3 CAGE		
REV. J		SHEET 2 OF 11		
SCALE		NTS		
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____